

Work Order ID 133008

133008

Page 1

Friday, May 22, 2015 11:43:08 AM

Item ID: PB67-43001-17

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/29/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: umf. Date: 5-5-27 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

B67-43001-17	Rev C
--------------	-------

100 Weld per dwg A/R Aluminum rod Batch: B128316 0.00
Large Fab

100

Large Fab

Large Fab

Memo

0.00

1- make a 0.090" chamfer in the 1.00" hole before welding

2- grind weld flush in area of PB67-43001-249 only

3- install helicol insert as per dwg

4- assemble parts and weld as per dwg

1x CC 15-6-15

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 15-06-17

DAS
9
9-89

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
120									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							DAS 9 9-89
150									
HandFinish	Memo	0.00							
Hand Finishing									
160	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating									
	1- MASK TUBE FROM BASE TO GUSSET START TIME: 8:55 OVEN TEMPERATURE: 200° FINISH TIME: 9:25								

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Page 3

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Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180		0.00							
180	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- match drill cover to existing holes in support2- assemble as per dwg								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
9
9-89

① 15-06-22

DAS
24
9-89

JUN 24 2015

1

DAS
9
9-89

① 15-06-24

Work Order ID 133008

133008

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Friday, May 22, 2015 11:43:08 AM

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <u>WA3</u>	0.00							
200									
Packaging	Memo	0.00							
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

1 JUN 24 2015 DAS 24 9-89

ML5 JUN 25 2015

ML5 JUN 25 2015

Picklist Print

Friday, May 22, 2015 11:43:08 AM

Page 1

Work Order ID: 133008

133008

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015

Required Date: 5/29/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.28 per rev C dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PB67-43001-71

Manufactured

No

Each

7.0000

1

PR67-43001-71

20° Blade Support Assembly*

**

CC 15-6-15

Location

Loc Qty

Loc Code

Mezz2

7

113382

7

PB67-43001-249

Manufactured

No

100

Each

0.0000

1

PR67-43001-249

Inner Tube Bushing

~~B133279~~ → (1x) **

CC 15-6-15

PB67-43001-253

Manufactured

No

100

Each

2.0000

1

PR67-43001-253

Gusset

B133228 → (1x) **

CC 15-6-15

Location

Loc Qty

Loc Code

Mezz2

2

116441

2

PB67-43001-254

Manufactured

No

100

Each

0.0000

1

PR67-43001-254

Gusset

B133227 → (1x) **

CC 15-6-15

PB67-43001-259

Manufactured

No

100

Each

0.0000

1

PR67-43001-259

Inner Tube

B133231 → (1x) **

CC 15-6-15

Picklist Print

Page 2

Friday, May 22, 2015 11:43:08 AM

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Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015

Required Date: 5/29/2015

Start Qty: 1.00

Required Qty: 1.00

MS124780

Purchased

No

180

Each

80.0000

1

1

MS124780

HELICAL INSERT

**

CL 15-6-15

Location

Loc Qty

Loc Code

ST260a

63

~~MS124780~~ → (1x)

m128173

63

ST317

17

111064

17

MS27039-1-10

Purchased

No

180

Each

364.0000

8

8

MS27039-1-10

SCREW

**

Location

Loc Qty

Loc Code

CA

41

m128635

41

GA

239

m129541

239

ST285

84

m123522

2

m130358

72

m130388

10

NAS1149D0316J

Purchased

No

180

Each

369.0000

8

8

NAS1149D0316J

Washer

**

JUN 23 2015

Location

Loc Qty

Loc Code

GA

156

122151

156

ST270

213

M127956

213

DAS
06
9-09

Picklist Print

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133008

Parent Item: PB67-43001-17

PB67-43001-17

Parent Item Name: Aft Adjustable Blade Support Assembly

Start Date: 5/22/2015

Required Date: 5/29/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

180

Each

2,186.000

8

8

NAS1149D0363.J

Washer

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

569

m130799

569

GA

222

m128429

222

ST269

1395

m126319

9

m131618

386

m132317

1000

8

PB67-43001-73

Manufactured

No

180

Each

12.0000

1

1

PB67-43001-73

20 Degree Cover Plate

DAS
06
9-89

Location

Loc Qty

Loc Code

Mezz2

12

111758

11

90817

1

1

PB67-43001-83

Manufactured

No

180

Each

24.0000

1

1

PB67-43001-83

D-Pad Assembly, Short

DAS
06
9-89

Location

Loc Qty

Loc Code

Mezz2

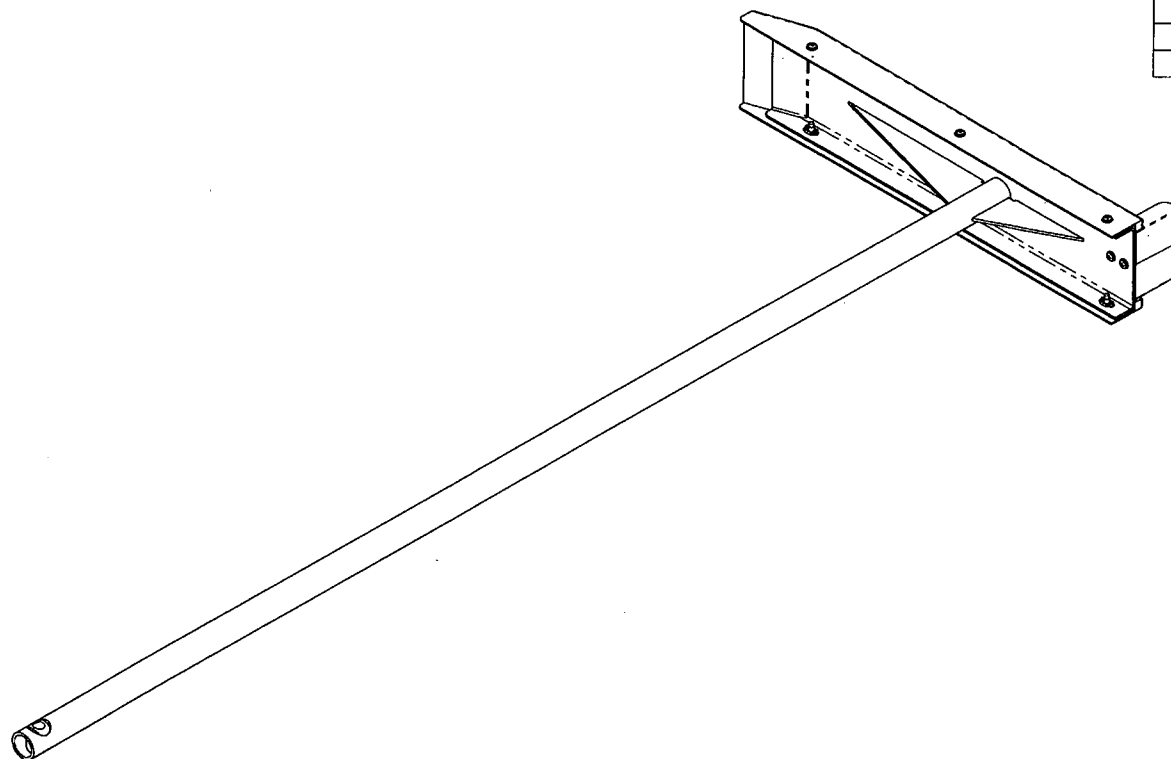
24

111757

24

1

JUN 23 2015



B67-43001-17 AFT ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -17	P/N	DESCRIPTION
1	X	B67-43001-17	AFT ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-73	20" COVER PLATE
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

mf
#133008

RELEASED
2010-09-16
mf

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	B67-43001-17	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS	
DATE	10.04.28		COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____

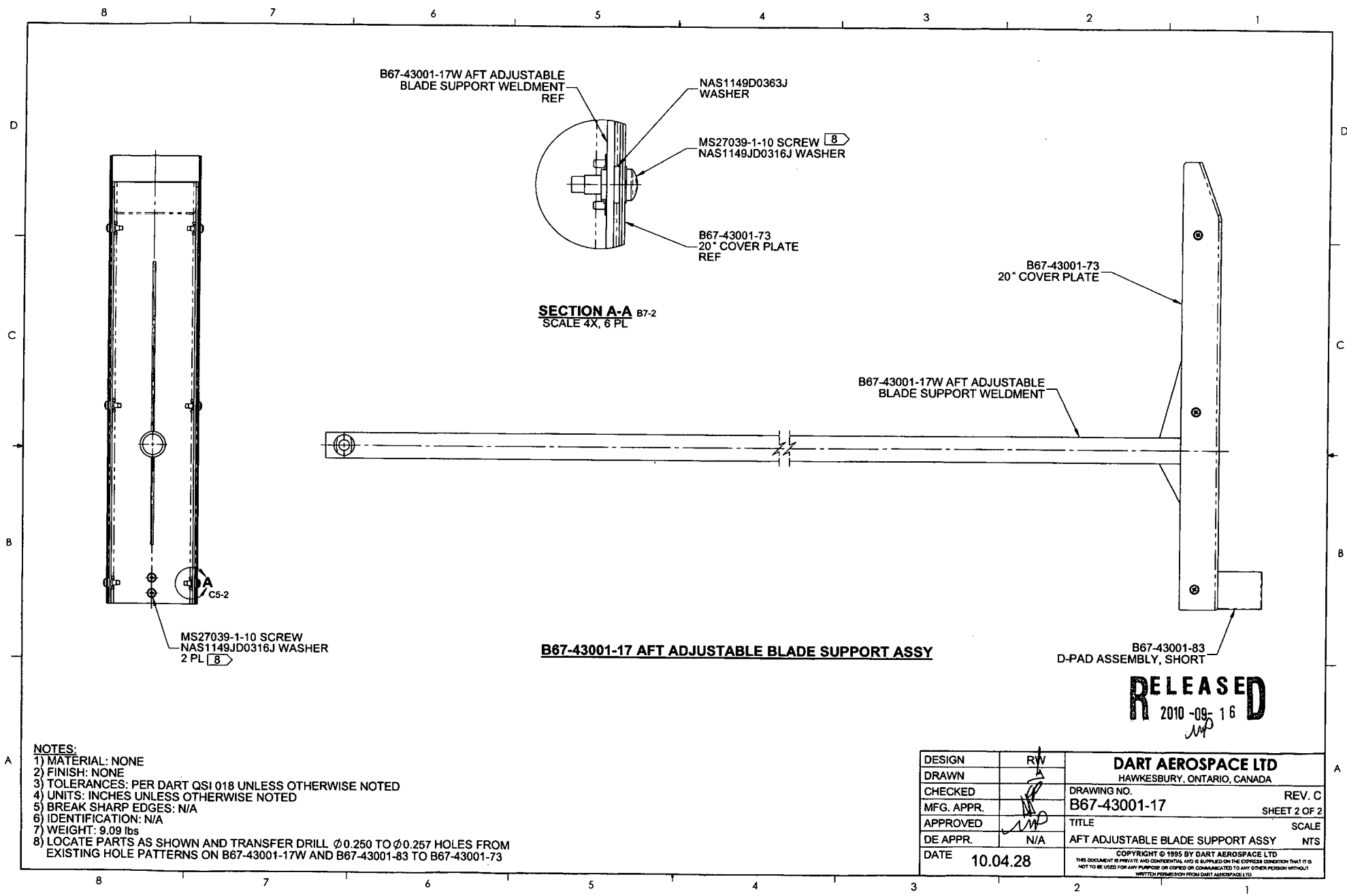


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					



- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.09 lbs
 - 8) LOCATE PARTS AS SHOWN AND TRANSFER DRILL $\varnothing 0.250$ TO $\varnothing 0.257$ HOLES FROM EXISTING HOLE PATTERNS ON B67-43001-17W AND B67-43001-83 TO B67-43001-73

RELEASED
2010-09-16

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-17	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT ASSY	NTS
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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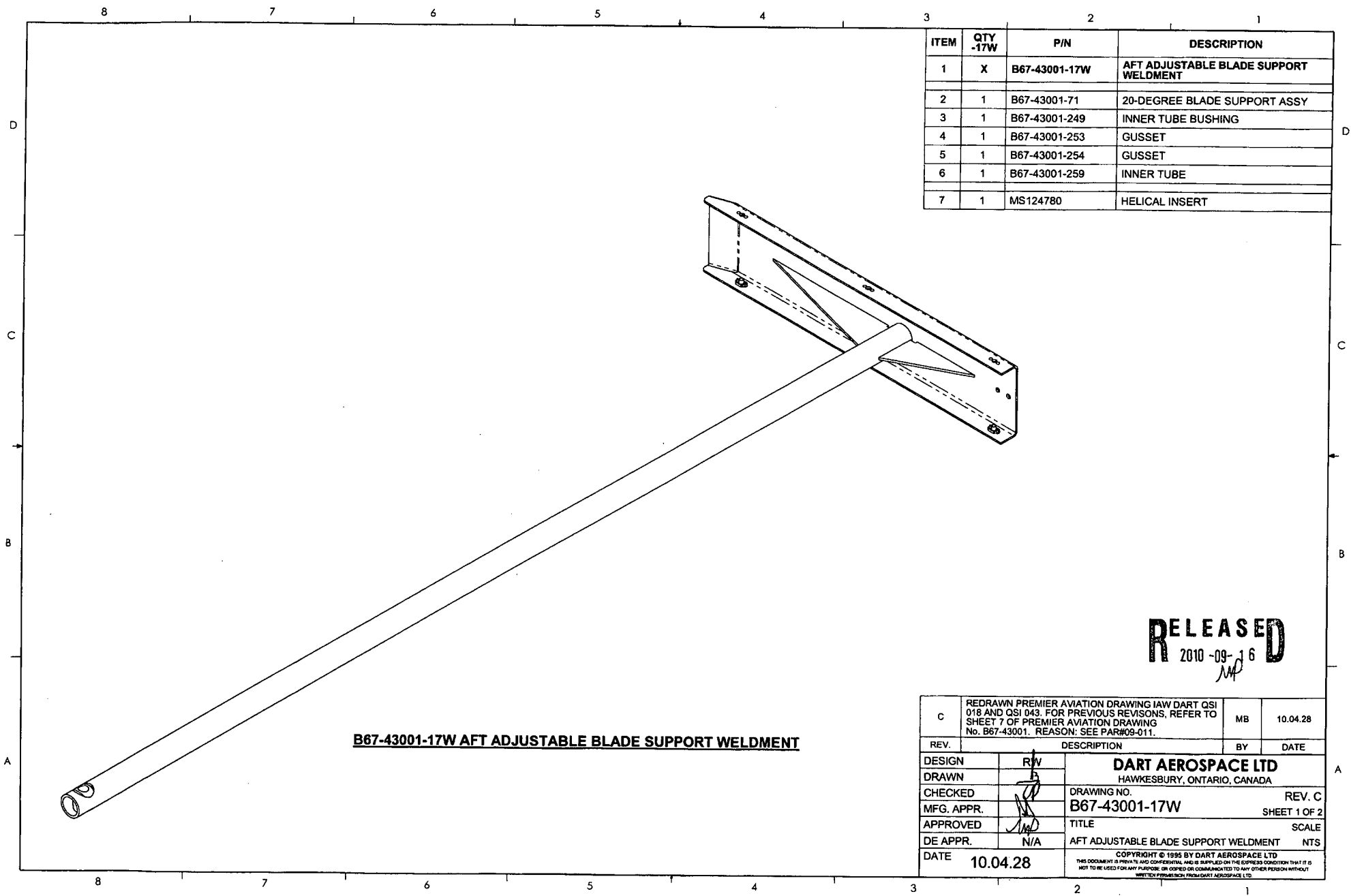


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																	
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																	
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																	
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																	
OTHER :																																																																				



ITEM	QTY -17W	P/N	DESCRIPTION
1	X	B67-43001-17W	AFT ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-71	20-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-249	INNER TUBE BUSHING
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-259	INNER TUBE
7	1	MS124780	HELICAL INSERT

B67-43001-17W AFT ADJUSTABLE BLADE SUPPORT WELDMENT

RELEASED
2010-09-16
MP

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 7 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C	
MFG. APPR.	<i>[Signature]</i>	B67-43001-17W	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	N/A	AFT ADJUSTABLE BLADE SUPPORT WELDMENT	NTS	
DATE	10.04.28	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

DQA: _____ Date: _____

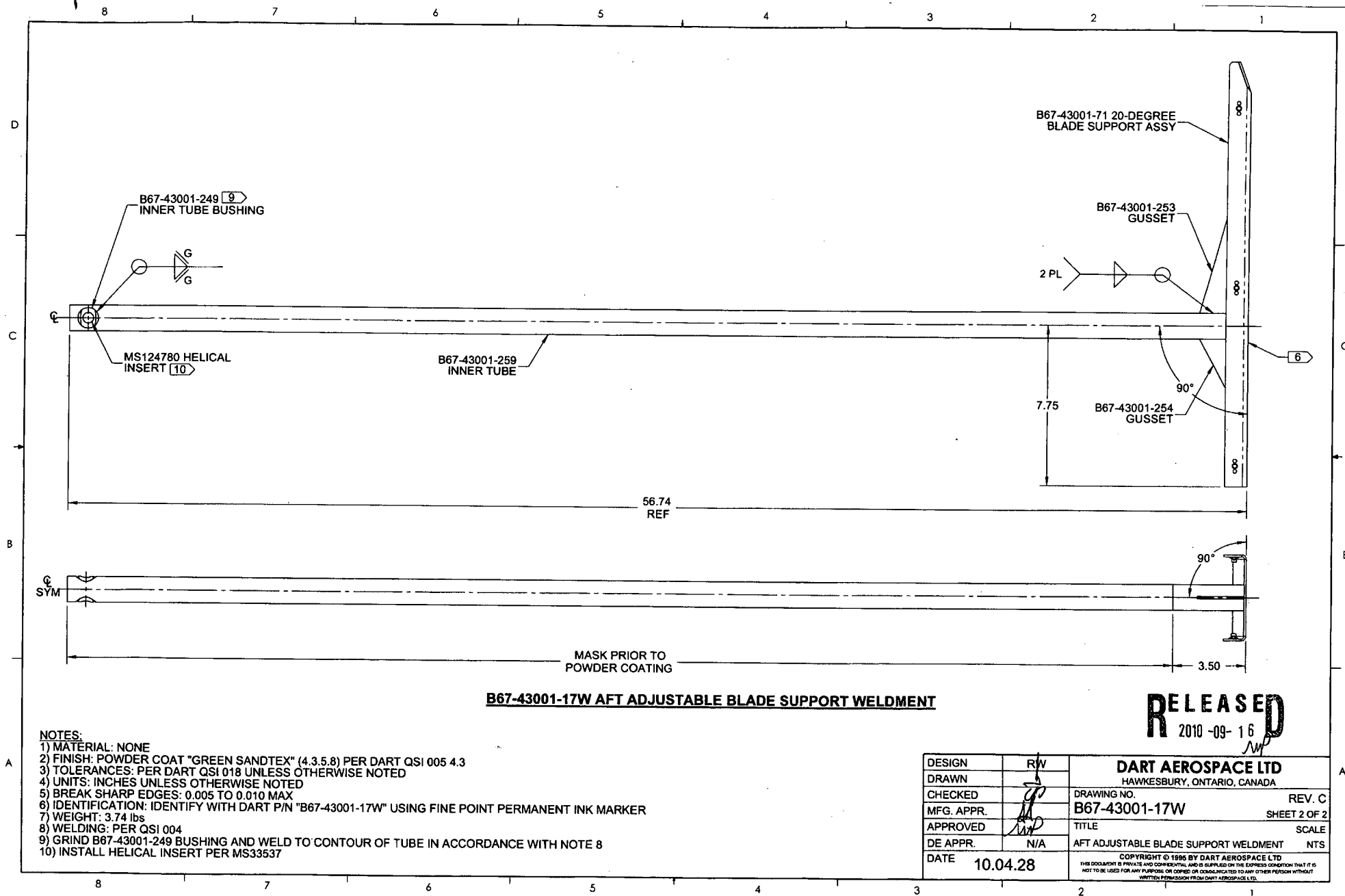


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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